

Date: Friday, 12/12/2008 7:40:38 AM
 User: Jean-Luc Menard

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SEAT RAIL		
Job Number	44028					
Estimate Number	13546					
P.O. Number	:		Part Number	D38111		
This Issue	12/12/2008	S.O. No. :	Drawing Number	D3811 REV A		
Prsht Rev.	NC		Project Number	N/A		
First Issue	11	Type : MACHINED PARTS	Drawing Revision	A		
Previous Run	41119		Material	:		
Written By	<i>JL 08-12-12</i>		Due Date	19/12/2008	Qty:	10 Um: Each
Checked & Approved By						
Comment	Est Rev:A New Issue 08-07-31 JLM Verified By:DD					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B1500X02500	6061-T6 Bar 1.50 x 2.50	
	Comment: Qty.: 2.1000 f(s)/Unit Total : 21.0000 f(s) 6061-T6 Bar 2.500x 1.50 Batch: <i>M16 +16</i>		<i>JL 08/12/14</i>
2.0	BAND SAW	BAND SAW	
	Comment: BAND SAW Cut blank 23.250 " long		<i>JL 08/12/14</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
	Comment: HAAS CNC VERTICAL MACHINING #1		
	1- Mill as per Folio FA776Rev: <i>A</i> & Dwg D3811 Rev: <i>A</i>		<i>JL 08/12/16</i>
	2-Deburr per dwg D3808		<i>JL 08/12/16</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<i>JL 08/12/16</i>
5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
	Comment: CONVENTIONAL MILLING MACHINE 1-DRILL REMAINIG HOLES		<i>JL 08/12/20</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: DLT-DAPROU Star Helicopters Services

Drawing Name: SEAT RAIL

Job Number: 44028

Part Number: D38111

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Jnl 08/12/20

(10)

7.0 QC8

SECOND CHECK



Comment: SECOND CHECK

Jnl 08.12.20

(10)

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Fd 08/12/22

(C)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST263.

SS 08/12/22 xD

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/22 D

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



N 08.12.22

W/O:		WORK ORDER CHANGES					
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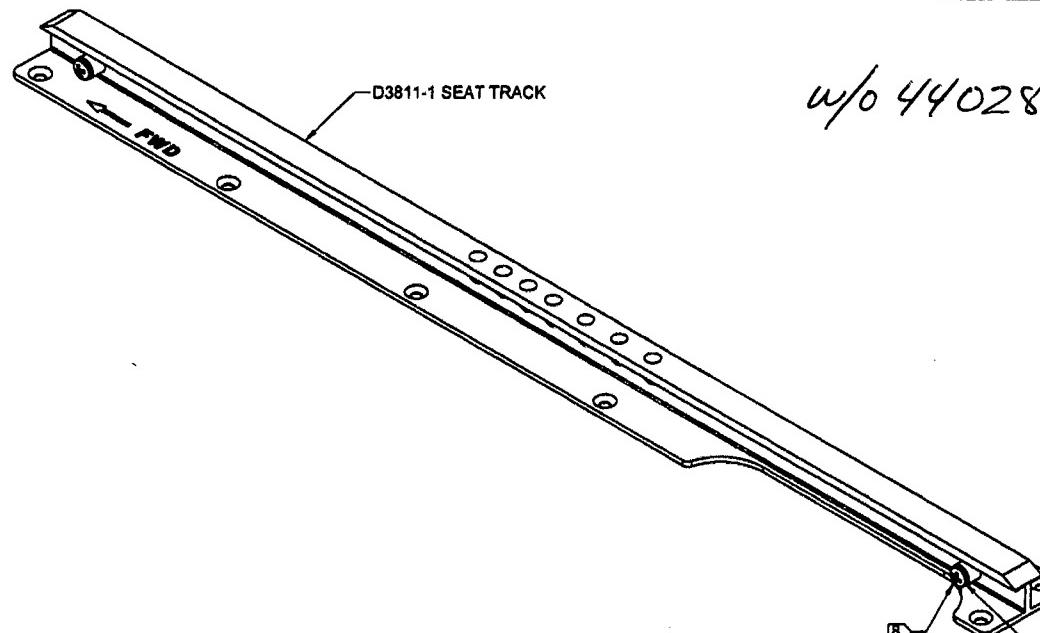
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY	P/N	DESCRIPTION
X	D3811-041	SEAT TRACK ASSEMBLY
1	D3811-1	SEAT TRACK
4	D3811-3	BUSHING
2	MS21042L3	NUT
2	MS27039-1-15	SCREW

w/o 44028

**D3811-041 SEAT TRACK ASSEMBLY****RELEASED**
(08-09-30/11)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3811-041 & B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.76 lbs
 - 8) TORQUE FASTENERS TO 20-25 in-lbs

A	NEW ISSUE		RF	08.08.18
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKSLEY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED		DRAWING NO.	REV. A D3811	
MFG. APPR.			SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		SEAT TRACK ASSEMBLY	NTS	
DATE	08.08.18		COPYRIGHT © 2008 BY DART AEROSPACE LTD THE DOCUMENT CONTAINS CONFIDENTIAL INFORMATION AND IS TO BE KEPT IN CONFIDENTIAL CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

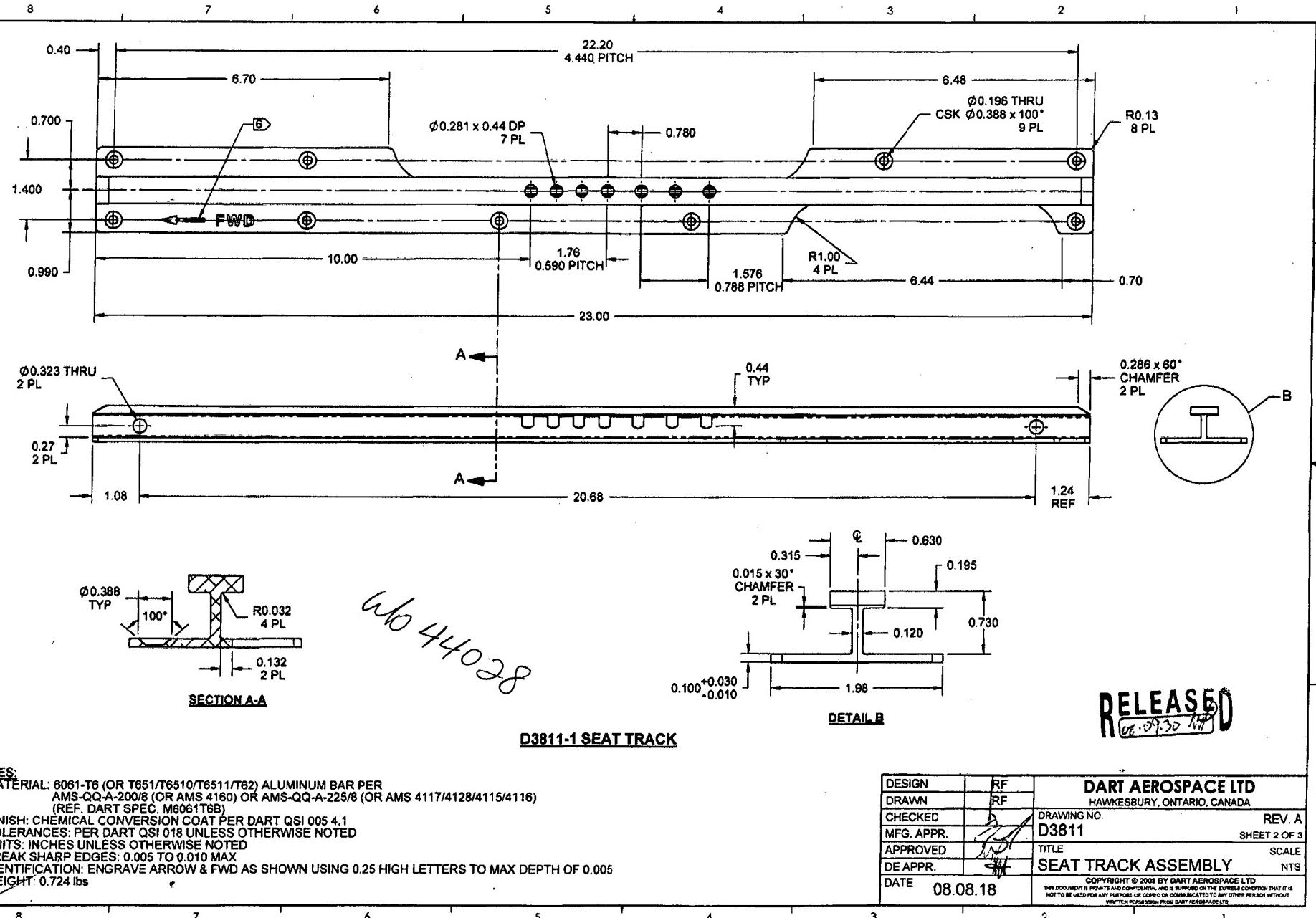
8 7 6 5 4 3 2 1

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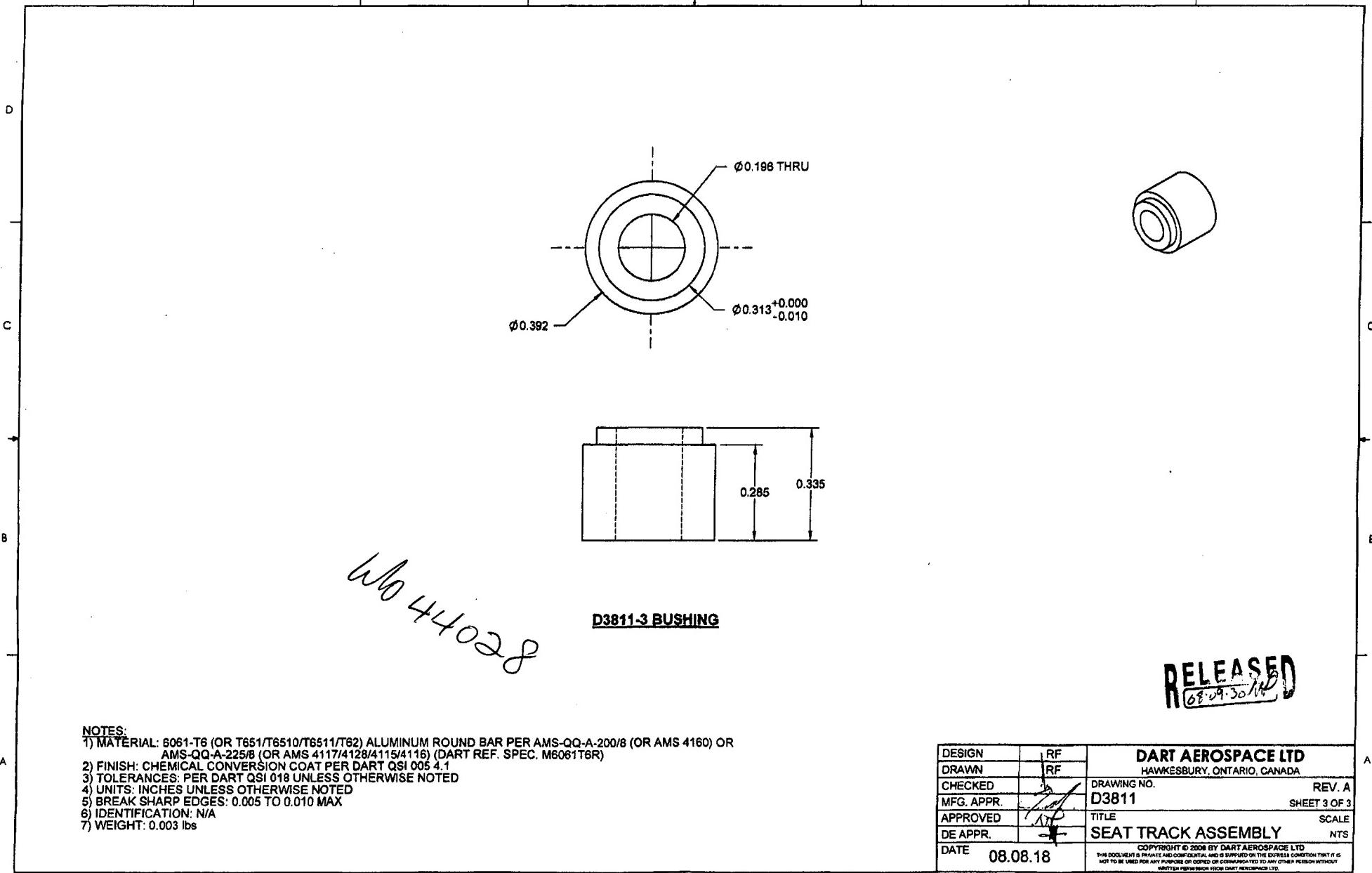
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

D

C

B

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	44028
Description: Seat Rail	Part Number:	D3811-1
Inspection Dwg:	Rev:	A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
22.20	± 0.030	22.20	✓			
0.40	± 0.030	0.399	✓			
6.70	± 0.030	6.700	✓			
6.48	± 0.030	6.480	✓			
$\phi 0.281$	$+0.006/-0.001$	0.284	✓			(7 Places)
0.44 Deep	± 0.030	0.445	✓			(7 Places)
0.780	± 0.010	0.780	✓			
$\phi 0.196$	$+0.005/-0.001$	0.199	✓			
CSK $\phi 0.388 \times 100^\circ$	$\pm 0.010 / +\frac{1}{2}^\circ$	0.395 / 100°	✓			(9 Places)
R 0.13	± 0.030	0.130	✓			
0.700	± 0.010	0.700	✓			(8 Places)
1.400	± 0.010	1.400	✓			
0.990	± 0.010	0.990	✓			
10.00	± 0.030	10.002	✓			
1.76	± 0.030	1.766	✓			
1.576	± 0.010	1.576	✓			
R 1.00	± 0.030	1.000	✓			(4 Places)
6.44	± 0.030	6.440	✓			
0.70	± 0.030	0.700	✓			
23.00	± 0.030	22.996	✓			
1.08	$\pm .030$	1.076	—			
1.24	$\pm .030$	1.240	—			
.27	$\pm .030$.268	—			

Measured by:	DTP/mkf	Audited by:	GJ	Prototype Approval:	N/A
Date:	08/12/16	Date:	69-12-22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	44028
Description: Seat Rail	Part Number:	D3811-1
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	DJP
Date:	08/12/16

Audited by:	
Date:	08.12.22

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	